

Work Order ID **107809**

Thursday, October 03, 2013 8:59:35 AM

107809

Page 1

Item ID: **D4410-5**

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Face Plate

Stop ***NS2***

Start Date: 10/3/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *ANF*

Date: *13-10-03*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4410

REV B

100

100

Waterjet

FLOW CNC Waterjet

6061.040

Memo

CUT AS PER DWG

DWG REV: 3

PROG REV: 3

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

*Scrap parts
R.C. New Rev
now at RWC*

DAS
9
9-89
14-12-11

Work Order ID 107809

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Page 2

Item ID: D4410-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Face Plate

Start Date: 10/3/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

170

Outsource process-Anodize per QSI017 4.1.10.1

0.00

170

Outsource4

Memo

0.00

Outsource process - Anodize

Issue P/O: _____

Black Anodize as per Dwg D4410

180

Receive & Inspect for Damage & Mat'l Certs

0.00

180

Packaging

Memo

0.00

Packaging

Work Order ID 107809

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Page 3

Item ID: D4410-5

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Face Plate

Start Date: 10/3/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/11/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

220

Identify as per dwg & Stock Location: _____

0.00

220

Packaging

Packaging

Memo

0.00

Packaging

230

QC21- Final Inspection - Work Order Release

0.00

230

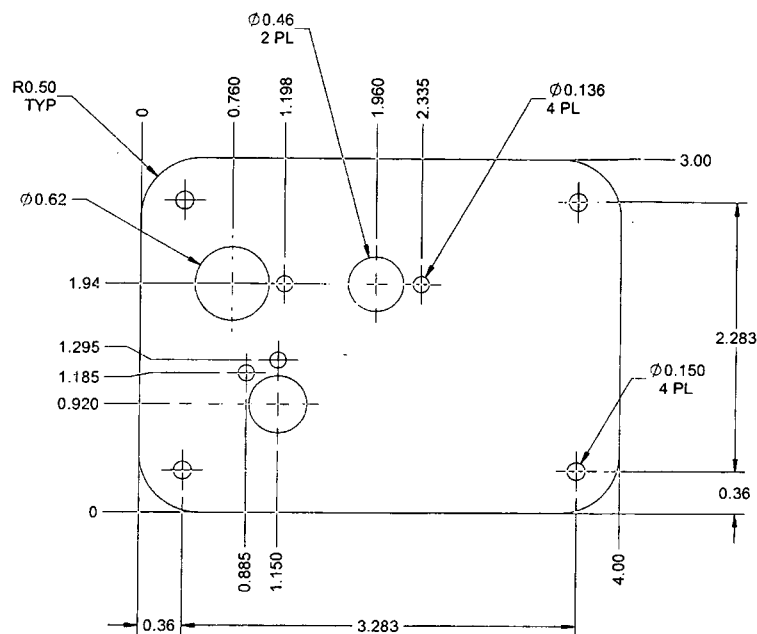
QC

Memo

0.00

Quality Control

SCAP
11-12-13



D4410-5 FACE PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK;
QQ-A-250/11 OR AMS-QQ-A-250/11
OP AMS 4025 OR AMS 4027
OP ASTM B209
REF. DART SPEC. M0061T6S.040
- 2) FINISH: ANODIZE BLACK PER MIL-A-8825F TYPE I OR II OR IC OR II OR IIC CLASS 2
- 3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2012-09-28
JND

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	PC	KENT, WA	
CHECKED	PC	DRAWING NO	REV. B
MFG. APPR.	PC	D4410	SHEET 7 OF 12
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CO-PILOT COLLECTIVE HEAD	
DATE	12.07.30	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE TITLE AND FOR NO OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

Picklist Print

Thursday, October 03, 2013 8:59:34 AM

Page 1

Work Order ID: 107809

Parent Item: D4410-5

Parent Item Name: Face Plate

Start Date: 10/3/2013

Required Date: 10/11/2013

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

408.0000

2

6061-T6 .040 Sheet

As 13.10.05

Location

Loc Qty

Loc Code

MAT021

408

m126350

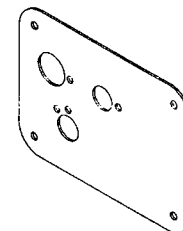
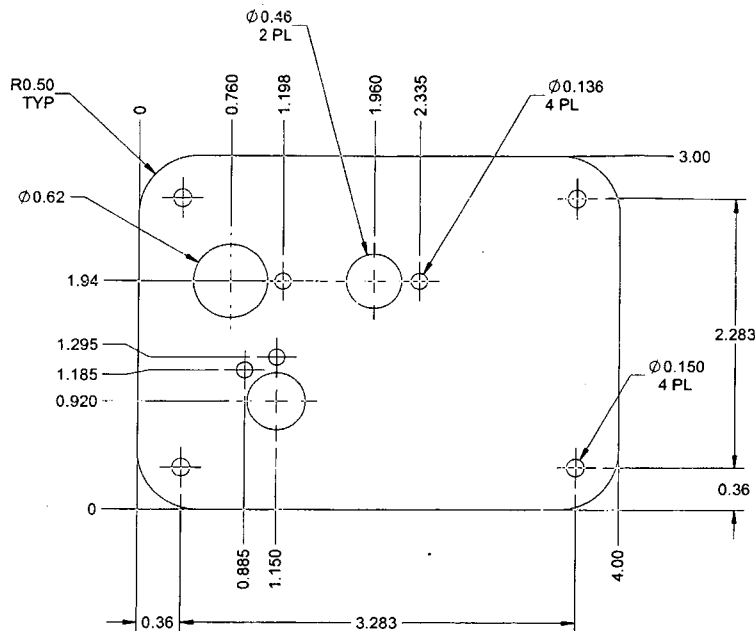
216

m126981

192

126350 →

102809



D4410-5 FACE PLATE

RELEASED
2012-09-28

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
- 2) FINISH: ANODIZE BLACK PER M.L.A-3825F TYPE I OR II OR IC OR II OR IIC CLASS 2
- 3) TOLERANCES: PER DART QSI 013 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	PLC	DART AEROSPACE USA, INC.	
DRAWN	PLC	KENT, WA	
CHECKED	PLC	DRAWING NO	REV. B
MFG. APPR.	PLC	D4410	SHEET 7 OF 12
APPROVED	PLC	TITLE	SCALE
DE APPR	PLC	CO-PILOT COLLECTIVE HEAD	HTS
DATE	12.07.30	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DRAWING IS UNCLASSIFIED AND IS RELEASED TO THE PUBLIC DOMAIN FOR REUSE AND REPRODUCTION BY ANYONE AT ANY TIME WITHOUT PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DART AEROSPACE LTD		Work Order: 107809
Description: FACE PLATE		Part Number: D4410-5
Inspection Dwg: 4410 Rev: 3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .620	+ .008 - .001	.620	-		✓	Jkm - 01
Ø .46	+ .006 - .001					
Ø .150	+ .005 - .001	.150	-		✓	
Ø .136	+ .005 - .001	.136	-		✓	
.920	+/- .010	.920	-		✓	
1.185	+/- .010	1.185	-		✓	
1.295	+/- .010	1.295	-		✓	
1.94	+/- .030	1.94	-		✓	
3.00	+/- .030	3.00	-		✓	
.760	+/- .010	.760	-		✓	
1.198	+/- .010	1.198	-		✓	
1.960	+/- .010	1.960	-		✓	
2.335	+/- .010	2.335	-		✓	
4.00	+/- .030	4.00	-		✓	
.36	+/- .030	.36	-		✓	
2.283	+/- .010	2.283	-		✓	
.36	+/- .030	.36	-		✓	
.885	+/- .010	.885	-		✓	
1.150	+/- .010	1.150	-		✓	
3.283	+/- .010	3.283	-		✓	

Measured by: Ae	Audited by:	Preliminary Approval:
Date: 13.10.05	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

David Duval

From: Daniel Campbell
Sent: Monday, October 07, 2013 10:48 AM
To: David Duval
Cc: Jean-Luc Menard; Mike Petsche; Linda Lacelle; Victoria Seib; Harvey Siemens
Subject: RE: D4410-5

Hi David,

Please use Rev. B of the dwg. We are waiting for David to review Rev. C.

In terms of the dwg/dxf mismatch, the dxf is correct. On D4410-5, one hole should be 0.460" and the other should be 0.484".

Cheers,
Dan

From: David Duval
Sent: October-07-13 7:18 AM
To: Daniel Campbell
Cc: Jean-Luc Menard; Mike Petsche; Linda Lacelle
Subject: RE: D4410-5

I bit of confusion. There is rev.b still in approved and a rev.pc2 in prelim, which one do we use and why is rev.b is not under review?

Thanks.

David Duval
Production Engineering Coordinator

From: David Duval
Sent: Monday, October 07, 2013 8:45 AM
To: 'Daniel Campbell (dcampbell@dartaero.com)'
Cc: Jean-Luc Menard; Mike Petsche
Subject: D4410-5

Dxf and dwg do not match. Dwg says two all at 0.460" but the dxf as one hole at 0.46" and the bottom one at 0.484". Which one is correct?

David Duval
Production Engineering Coordinator

No virus found in this message.

Checked by AVG - www.avg.com

Version: 2013.0.3408 / Virus Database: 3222/6722 - Release Date: 10/04/13